

# Work Order ID 70765

Wednesday, June 15, 2011 9:06:18 AM



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Item ID:	D3283-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	6/15/2011	Start Qty:	30.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-06-15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3283	Rev E								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3283 <input type="checkbox"/> Dwg Rev: <u>E</u> <input type="checkbox"/> Prog Rev: <u>E</u> <input type="checkbox"/> 2-								
6061 .063	Deburr if necessary								

B11-6-22

(30)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-6-22

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8 wlog/23

count  
(X30)  
B11-6-22

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Item ID: D3283-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/15/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	*****ensure rivet fits in #30 (0.128") holes as per dwg *****								
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

30  $\phi$  BL 11-6-27.

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Item ID: D3283-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 6/15/2011 Start Qty: 30.00

Required Date: 6/22/2011 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

30.00 11/6/27

170

Identify as per dwg &amp; Stock Location: 045

0.00

Packaging

Memo

0.00

Packaging

11/6/28 (30)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/28

MF

11-06-28

# Picklist Print

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Work Order ID: 70765

Parent Item: D3283-1

Parent Item Name: Doubler




Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ A ☐ 04.09.28 ☐ New issue ☐ KJ/JLM ☐  
 IPP Rev:B Now on Waterjet 07-05-28 JLM  
 IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	251.6700	0.2361	7.455789			
													

6061-T6 .063 Sheet



B11-6-22

Location

Loc Qty

Loc Code

MAT021

251.67

116308

29

117285

222.67

117285

30



**DART****RELEASED**  
07.08.12 AH  
PER ECN 959

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>HT</i>	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	

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RETURN TO

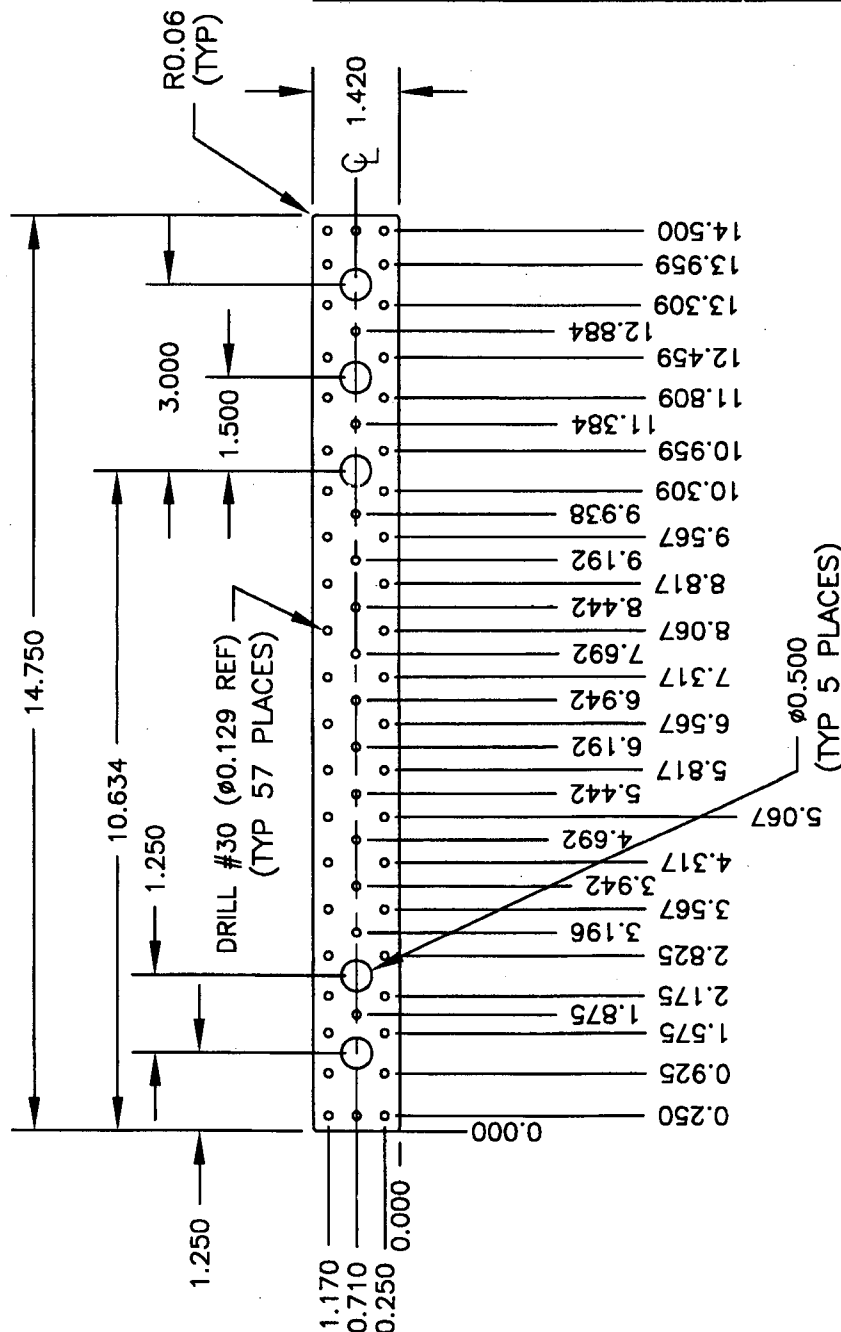
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WORK ORDER

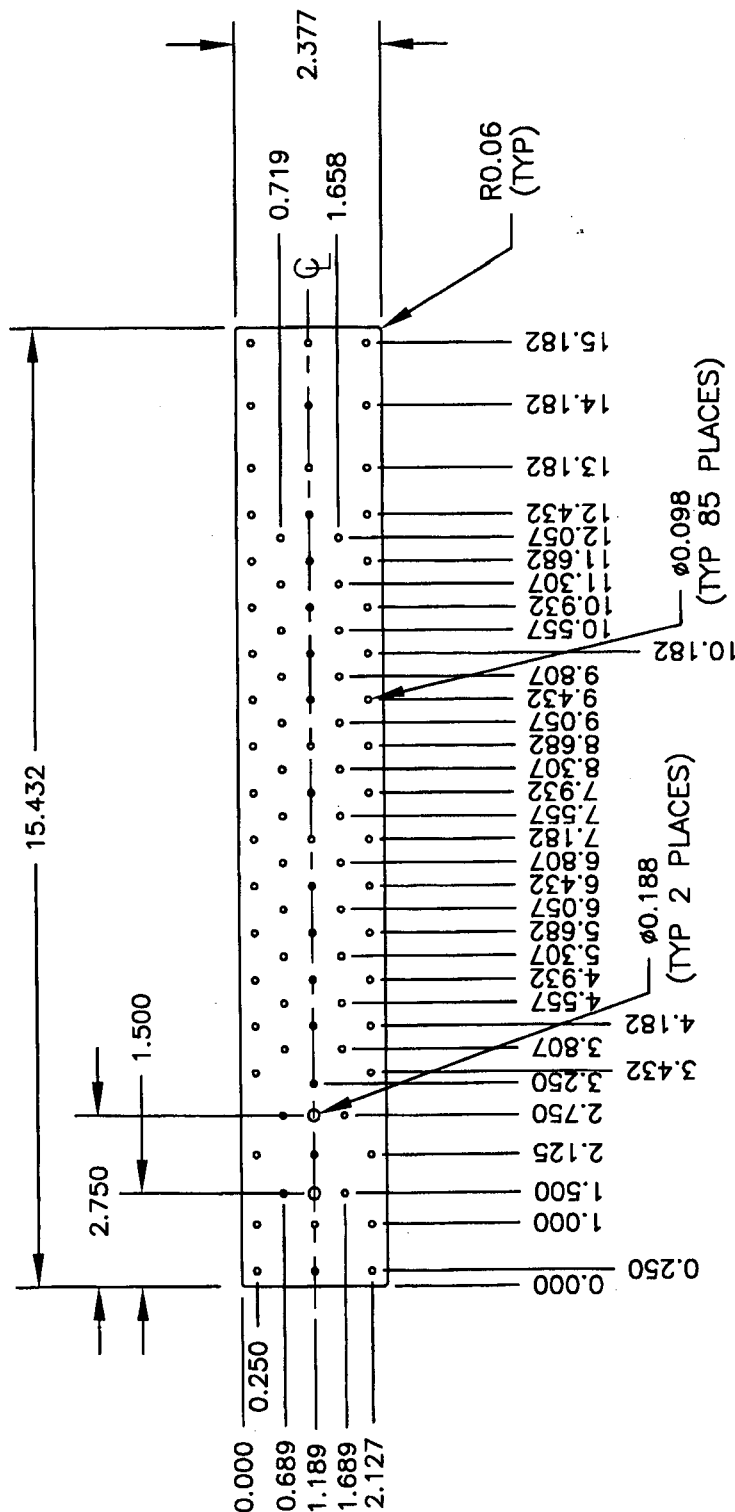
NO. *70265*



DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3

**RELEASED**  
07.08.2004  
PER ECN 959

*u010165*



**D3283-3 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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